Quality Control



Tuesday, February 09, 2010 12:36:30 PM

DSK077 Item ID: Accept Setup Start **Revision ID:** Stop **D2892-1 TURNING DETAIL** Item Name: Start Qty: 7.00 **Start Date:** 2/10/2010 **Cust Item ID:** Required Date: 2/23/2010 Req'd Qty: 7.00 **Customer:** Reference: Run Start Date: 10-2-9 Process Plan: MF Tooling: Approvals: Date: Stop QC: Date: Date: SPC (Y/N): Sequence ID/ Operation Set Up/ Reject Draw Plan Draw Accept Reject Insp. Work Center ID Description Qty Qty **Run Hours** Number Rev. Code Number Stamp Draw Nbr **Revision Nbr** DSK077 Rev A 100 0.00 MORI SEIKI CNC LATHE LARGE Doosan 0.00 Memo 10/02/22 Doosan Lathe Turn blank as per Folio FA082 110 QC2- Inspect parts off machine FAI/FAIB 0.00 JL 10/02/22 QC 0.00 Memo Quality Control 1. 8 10/01/22 120 QC8- Inspect parts - second check 0.00 0.00 Memo

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	

Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Ammassal	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng					
								:				
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NOTE: Date & initial all entries

Resolution:

Work Order ID 56045

Page 2

Tuesday, February 09, 2010 12:36:30 PM

Item ID:

DSK077

Accept

Setup Start

Stop



Revision ID:

Item Name:

D2892-1 TURNING DETAIL

Start Date:

2/10/2010

Start Qty: 7.00

Rea'd Oty: 7.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 2/23/2010

Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

Qty

Reject

Number

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan

Code

Stop

Insp.

Stamp

Sequence ID/ Work Center ID

130

Packaging Packaging

Packaging

Operation

Description

0.00

Memo

Identify and Stock in Kanban CLocation: C, W, C

A P 10/02/22

Draw

Number

Accept

Qty

140

QC Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

10/02/23 XI) MUF 10-2-23

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	۸:	Date: _	
	Re	esolution:	Dispositio	n:	_ QA: N/C Cld	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	()			
		Description of NC		Corrective Action Section B		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
						2			
					i i	1		1	1

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 09, 2010 12:36:30 PM

Work Order ID: 56045

Parent Item:

DSK077

Parent Item Name:

D2892-1 TURNING DETAIL

Comments:

IPP rev A. 08.03.13 new issue EC

Start Date: 2/10/2010

Required Date: 2/23/2010

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Route Location Seq ID

Last

Unit of Measure Hand

Qty on

Remaining Qty To Pick Issued

Date Issued

Status

Page 1

D6104-003

Round Billet, 17-4

Manufactured

No

Each

20.0000

7.0000

Warehouse Loc Qty Loc Code Location Main Warehouse MAT 20 53750 20

7 JL 10/02/22

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
						•			
Part No	:i	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	•	QA: N/C C	losed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
D.4		Description of NC	Corrective Action Secti			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	Verification Section C	Chief Eng	QC Inspecto
			·						1
								1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56045
Description: Turning Detail for D2892-1	Part Number:	DSK077
Inspection Dwg: DSK077 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

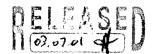
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			X First A	Article [Proto	type		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
	 			Lathe Section	n			
Α	2.524	2.529		2.525	2.525	2.527	2526	2.527
В	3.702	3.722		3.7/2	3.711	3.7/2.	3.7/2.	3-7/3
С	2.814	2.834		2.824	2.824	2.824	2.824	2.824
D	0.718	0.738		-728	-428	7328	-725	728
E	0.090	0.110		.100	.100	.100	100	-100
F	2.714	2.734		2.724	2724	2724	2724	2-724
G	2.029	2.049		5.038	2-038 3-224	2.038	2.038	2.038
Н	3.214	3.234		3-224	3.224	3,224		3,224
1	0.913	0.933		923	923	.923	. 923	-923
J	0.022	0.042		. 032	-032	-032	-032	.032
K	0.090	0.110		./0/	-101	- 100	101	-160
L								<u> </u>
М								
N								
0								
Р					<u> </u>			
								100
	Measured	by:	SL			Date:	10/02	22
	Audited	by: 8	, E			Date:	10/02/7	
Proto	type Appro	val:				Date:		
Rev	Date	Change		<u>,,</u>		Re	vised by	Approved
A		New Issue					/JLM A	Cill

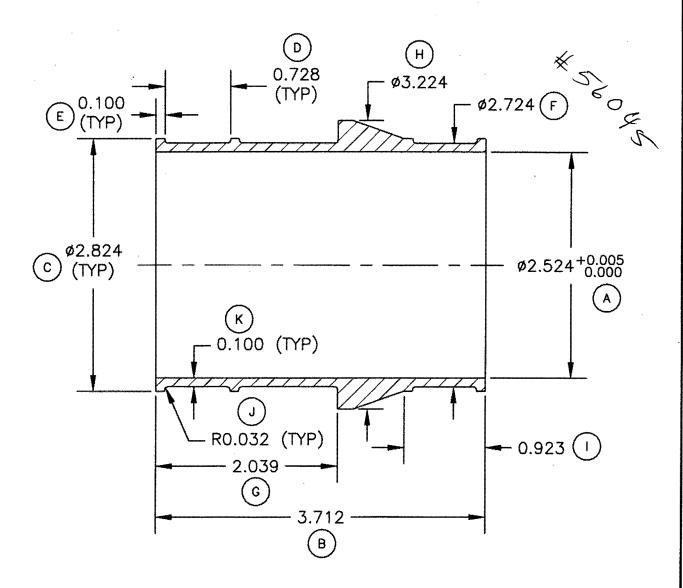
DART AEROSPACE LTD	Work Order:	56045
Description: Turning Detail for D2892-1	Part Number:	DSK077
Inspection Dwg: DSK077 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET										
			X First A	Article	Protot	ype				
					Record A	Actual Dime	ensions			
Dim	Min	Max	Go/No Go Gauge	76	47	Ŕ	A	5		
				Lathe Section	on		<u> </u>	1		
Α	2.524	2.529		2,528	2571					
В	3.702	3.722		3.7/3	2.4/2	-				
С	2.814	2.834		2824	2.824					
D	0.718	0.738		-728	728					
E	0.090	0.110		./00	-100					
F	2.714	2.734		2724	2.724					
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Н	3.214	3.234		3,224	3.224					
1	0.913	0.933		. 923	-923	· · ·				
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	CHECH	(ED)	APPROVED	DRAWING NO. DSK 077 SI	REV. A
-	DATE			TITLE	SCALE
	03.0	5.20		TURNING DETAIL FOR D2892-1	1:1
	Α		03.05.20	NEW ISSUE	





D2892-1 TURNING DETAIL

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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE STE		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No: _		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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NOTE: Date & initial all entries